

8622/04

Work Order ID 68041

Tuesday, April 05, 2011 3:12:34 PM



Page 1

Item ID: D3915-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Light Lid Assembly, Long Basket

Start Date: 4/5/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 4/8/2011 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3915	C								

100



Large Fab

Large Fab

Weld per dwg A/R Aluminum rod Batch: 1112860.00
Large Fab

Memo

0.00

1- assemble ribs , weld as per dwg D3915 using DT9606A. When welding D4019-3, weld top and bottom then make a small hole in the weld to let air out. Then weld remaining sides of D4019-3 Rib. Let it cool down, then block holes with weld.

****DO NOT WELD THE (4) CORNERS. GRIND OFF CORNERS TO HAVE A 1/8" GAP TO GET THE ACID AND ALODINE OUT OF BASKET LID FRAME****

2- weld hinge, label plate and Mounting plates as per dwg D3915

11.04.07 (1x)

110



QC

Quality Control

QC9- Inspect visual per QSI004- Fusion Welds 0.00

Memo

0.00

1 8 BE 11/04/07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 68041

Page 2

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Item ID: D3915-041

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Item Name: Light Lid Assembly, Long Basket

Start Date: 4/5/2011 Start Qty: 1.00



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Required Date: 4/8/2011 Req'd Qty: 1.00



Customer:

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Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

130

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

ENSURE TO RINSE CAREFULLY ACID AND ALODINE

140

Weld per dwg A/R Aluminum rod Batch: _____

0.00



Large Fab

Memo

0.00

Large Fab

1- weld (4) corners

M112860

1 BL 11-4-8

11-04-11 (1x)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

QC9- Inspect visual per QSI004- Fusion Welds

0.00



QC

Memo

0.00

Quality Control

*1 0 BE11/04/11

155

QC6- Inspect dimensions to drawing

0.00



QC

Memo

0.00

Quality Control

Subonly



inspect fit of lid with base

157

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

1- realodine corners
do not acid etch

1 BR 11-4-12.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Tuesday, April 05, 2011 3:12:35 PM



[REDACTED]

[illegible][illegible][illegible]

Customer:

.....

.....

**Insp.
Stamp**

1. **THESE** are the conditions of sale for the purchase of the above described goods, and the purchaser agrees to accept the same.

M 116964.

0.00

- 1- touch up corner with alodine only
- 2- Plug holes prior to

1ST COAT: 9:20
START TIME: 3:20
OVEN TEMPERATURE: 320°
FINISH TIME: 4:50

*****2nd coat if necessary*****

2ND COAT:

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

0.00

Figure 1

QC

Memo

0.00

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Tuesday, April 05, 2011 3:12:35 PM

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Revision ID:					Stop	
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Start Date:	4/5/2011	Start Qty:	1.00		Cust Item ID:	
Required Date:	4/8/2011	Req'd Qty:	1.00		Customer:	
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180 	Assemble as per dwg	0.00							
HandFinish 	Memo	0.00							
Hand Finishing	1- Install webbing as per dwg								
	2- Install placard and label as per dwg								
190 	QC5- Inspect part completeness to step on W/O	0.00							
QC 	Memo	0.00							
Quality Control									
200 	Identify as per dwg & Stock Location: <u>G A</u>	0.00							
Packaging 	Memo	0.00							
Packaging	<u>w/o</u> <u>67910</u>								

EP 11/04/13 (1)

W 11 04 13 (1)

EP 11/04/13 (1)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 6

[illegible][illegible]

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Cust Item ID:

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Customer:

Abstract

...the ...

SPC (Y/N): _____ Date: _____

**Insp.
Stamp**

0.00

1. The first step in the process is to identify the problem or issue that needs to be addressed. This involves gathering information and understanding the context of the problem.

QC

Memo

0.00

Quality Control

Number Stamp
11/4/14 [Signature]
MF
11-04-13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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NOTE: Date & initial all entries

Tuesday, April 05, 2011 3:12:39 PM




Page 1



A standard linear barcode consisting of vertical black bars of varying widths on a white background.

Required Date: 4/8/2011

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2957  Mounting Plate		Manufactured	No			100	Each	15.0000	4	4		11.04.07	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				WA005				15					
				63664				5					
				63750				10					
D3915-1  Rib		Manufactured	No			100	Each	4.0000	2	2		11.04.07	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				WA006				4					
				66616				4					
D4016-5  Hinge Half, Light Lid		Manufactured	No			100	Each	15.0000	3	3		11.04.07	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				WA005				15					
				63751				1					
				66335				8					
				66541				6					

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval: QC Inspector

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

Page 2

Tuesday, April 05, 2011 3:12:39 PM

Work Order ID: 68041

Parent Item: D3915-041

Parent Item Name: Light Lid Assembly, Long Basket

Start Date: 4/5/2011

Required Date: 4/8/2011

Start Qty: 1.00

Required Qty: 1.00

D4019-3 Manufactured No

100 Each

3.0000

3

3



Rib



B66726 (3) SJ 11.04.07

LocationLoc QtyLoc Code

WA006

3

64430

3

D4035-045 Manufactured No

100 Each

2.0000

1

1



Lid Rib Assembly, Fwd (Light)



SJ 11.04.07

LocationLoc QtyLoc Code

WA006

2

64431

1

66539

1

D4035-047 Manufactured No

100 Each

2.0000

1



Lid Rib Assembly, Aft (Light)



(12) SJ 11.04.07

LocationLoc QtyLoc Code

WA006

2

66540

2

D4056-1 Manufactured No

100 Each

5.0000

1



Label Plate



(12) SJ 11.04.07

LocationLoc QtyLoc Code

WA005

5

58308

3

59750

2

D2728-1 Manufactured No

180 Each

0.0000

1

1



Dart Logo label



Tuesday, April 05, 2011 3:12:40 PM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
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Picklist Print

Tuesday, April 05, 2011 3:12:40 PM

Work Order ID: 68041



Parent Item: D3915-041



Parent Item Name: Light Lid Assembly, Long Basket

Start Date: 4/5/2011

Required Date: 4/8/2011

Start Qty: 1.00

Required Qty: 1.00

D4029-041 Manufactured No

180

Each

1.0000

1

1



Webbing (Long Basket)



SB 11/04/13

LocationLoc QtyLoc Code

st503

1

58109

1

MS20600-AD4W3 Purchased No

180

Each

931.0000

34

34



Cherry Rivets



SB 11/04/13

LocationLoc QtyLoc Code

ST321

494

111636

494

WA018

437

107939

437

NAS1149DN416J Purchased No

180

Each

419.0000

34

34



Washer



SB 11/04/13

LocationLoc QtyLoc Code

ST298

419

114348

11

114597

323

13910

85

34

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

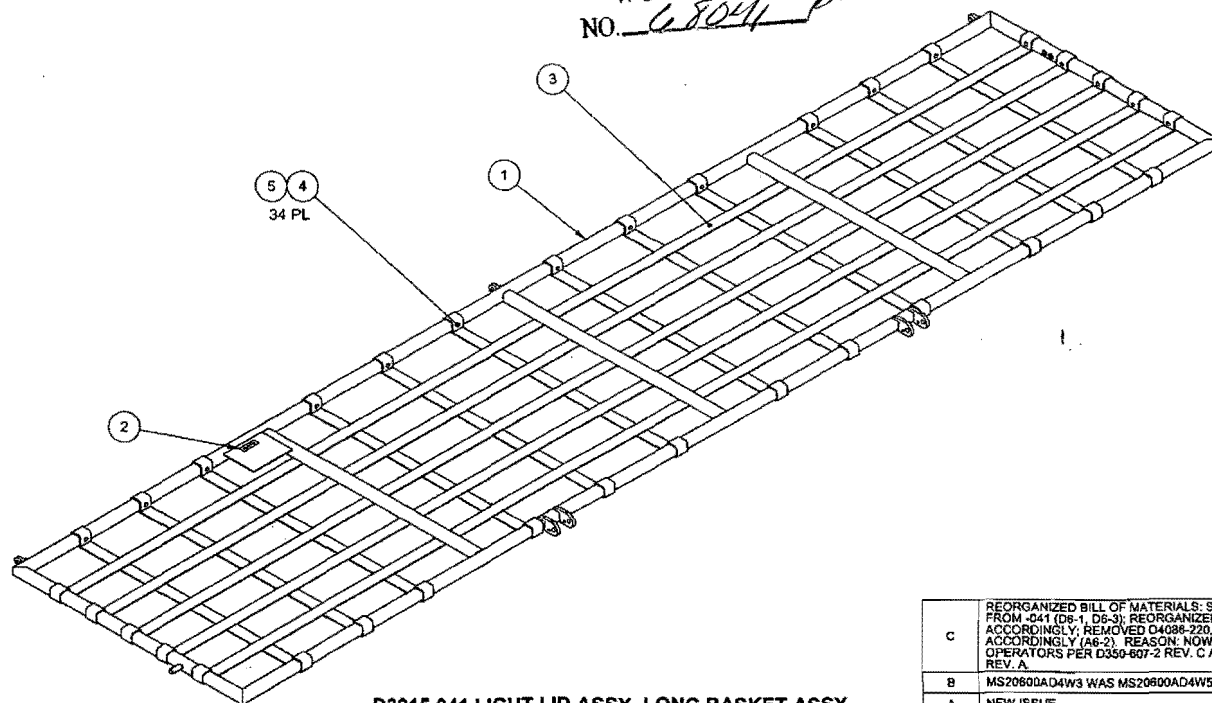
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

ITEM	QTY -041	P/N	DESCRIPTION
	X	D3915-041	LIGHT LID ASSY, LONG BASKET ASSY
1	1	D3915-101	BASKET LID WELDMENT ASSY
2	1	D2728-1	DART LOGO LABEL
3	1	D4029-041	WEBBING (LONG BASKET)
4	34	MS20600AD4W3	BLIND RIVET
5	34	NAS1149DN416J	WASHER

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 68044 PL 11-04-5



D3915-041 LIGHT LID ASSY, LONG BASKET ASSY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 6.91 lbs

RELEASED
10-20-12
ECN 10-596

C	REORGANIZED BILL OF MATERIALS: SEPARATED -101 FROM -041 (D8-1, D6-3); REORGANIZED VIEWS ON SHT 3 ACCORDINGLY; REMOVED 04086-220, UPDATED VIEW E ACCORDINGLY (A6-2) REASON: NOW INSTALLED BY OPERATORS PER D350-607-2 REV. C AND D350-607-3 REV. A	MB	10.08.05
B	MS20600AD4W3 WAS MS20600AD4W5: BOM & (B1-2)	JPH	10.04.08
A	NEW ISSUE	JPH	10.03.16
REV.	DESCRIPTION	BY	DATE
DESIGN	ALLS		
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	10.08.05		
DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D3915 REV. C SHEET 1 OF 4 TITLE LIGHT LID ASSY-LONG BASKET SCALE <small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PREPARED AND FOR INTERNAL USE ONLY. IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY FORM OR BY ANY MEANS WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE LTD.</small>			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

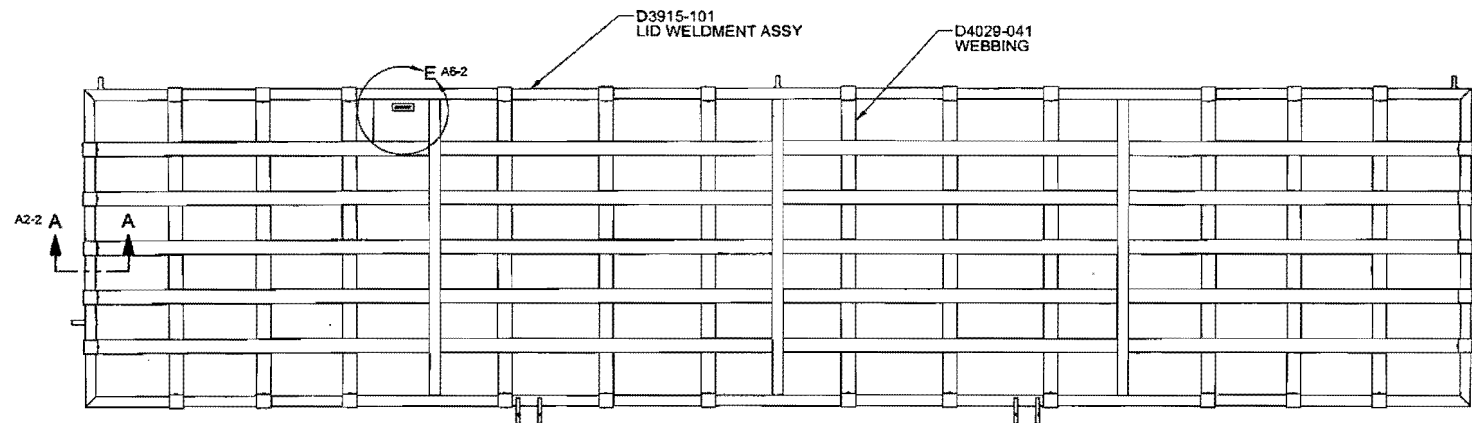
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

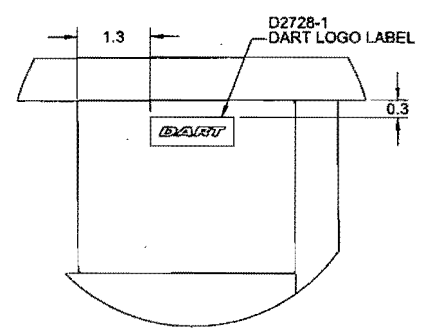
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

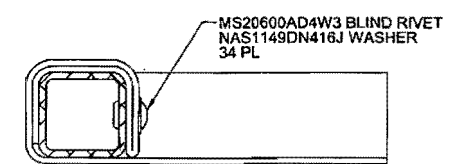
W/O 68041



D3915-041 LIGHT LID ASSY, LONG BASKET



VIEW E D6-2



SECTION A-A C8-2

RELEASED
10-00-17

DESIGN	AS	DART AEROSPACE LTD	
DRAWN	AS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	SC	DRAWING NO. D3915	REV. C
MFG. APPR.	AS	SHEET 2 OF 4	
APPROVED	AS	SCALE	
DE APPR.	AS	LIGHT LID ASSY-LONG BASKET	
DATE	10.08.05	<small>COPYRIGHT © 2018 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR REPRODUCED IN ANY MANNER WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

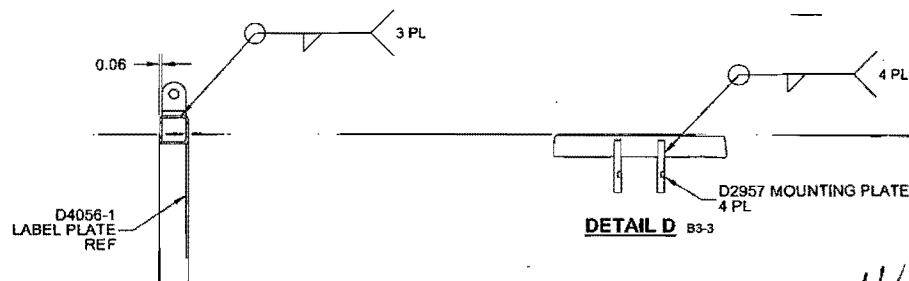
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ITEM	QTY	P/N	DESCRIPTION
	X	D3915-101	BASKET LID WELDMENT ASSY
1	4	D2957	MOUNTING PLATE
2	2	D3915-1	RIB
3	3	D4016-5	HINGE HALF, LIGHT LID
4	3	D4019-3	RIB
5	1	D4035-045	BASKET LID RIB ASSY, FWD (LIGHT)
6	1	D4035-047	BASKET LID RIB ASSY, AFT (LIGHT)
7	1	D4056-1	LABEL PLATE, 350 LIGHT BASKET



W/O 6804

D4035-045
LID RIB ASSY, FWD

DETAIL C C8-3

D3915-1 RIB
2 PL

D4016-5 HINGE HALF
3 PL

4 PL

D4019-3 RIB
3 PL

6 PL

D4035-047
LID RIB ASSY, AFT

SECTION B-B
B7-3

D3915-101 BASKET LID WELDMENT ASSY

RELEASED
10.08.05

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 4.81 lbs
- 8) WELD PER DART QSI 004

DESIGN	ACS	DART AEROSPACE LTD	
DRAWN	SC	HAWKESBURY, ONTARIO, CANADA	
CHECKED	SC	DRAWING NO.	REV. C
MFG. APPR.	SC	D3915	SHEET 3 OF 4
APPROVED	SC	TITLE	SCALE
DE APPR.	SC	LIGHT LID ASSY-LONG BASKET	INTS
DATE	10.08.05	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

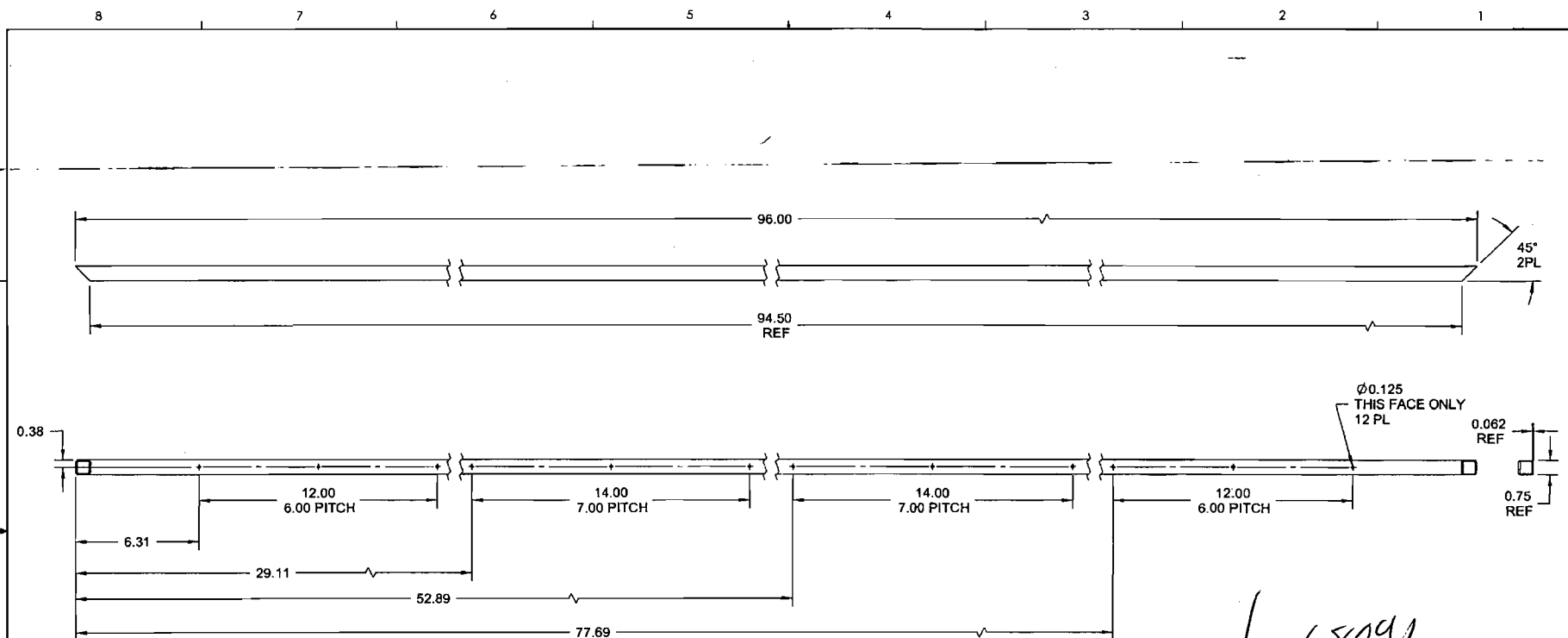
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D3915-1 RIB

w/o 4804

RELEASED
10.09.12

- NOTES:**
- 1) MATERIAL: 6061-T6 (OR 6061-T651/ T6510/ T6511/ T62) SQUARE TUBING
PER AMS-QQ-A-225/8 (OR AMS 4117/ 4128/ 4115 / 4116) OR
PER AMS-QQ-A-200/8 (OR AMS 4160)
REF DART SPEC. M6081T6TS0.750W.062
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 1.49 lbs

DESIGN	ALS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	SC	DRAWING NO. D3915	REV. C
CHECKED	MS	SHEET 4 OF 4	
MFG. APPR.	MS	SCALE	
APPROVED	MS	TITLE LIGHT LID ASSY-LONG BASKET	
DE APPR.	MS	TNTS	
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries